

Date: Tuesday, 15/07/2008 9:15:32 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP
Job Number	: 40493		
Estimate Number	: 11119		
P.O. Number	:	Part Number	: D30411
This Issue	: 15/07/2008 S.O. No. :	Drawing Number	: D3041 REV.C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 39098	Material	:
Written By	:	Due Date	: 15/08/2008 Qty: 40 Um: Each
Checked & Approved By	: <u>JUL 08.15.08</u>		
Comment	: Est:A 01.07.11 New Issue SM est B 07.04.09 rev.c dwg EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2423	Lug Extrusion
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Comment: Qty.: 0.0875 f(s)/Unit Total: 3.4986 f(s)

Lug Extrusion

(D2423)

Batch: B33310

2.0	BAND SAW	BAND SAW
-----	----------	----------

at meter

Comment: BAND SAW

Cut D2423 Extrusion: 1.250" Long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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issue 7/10 6778 meter CL 08/07/15 (40)

Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio FA153

machine as per dwg.D3041 REV.CPG

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

RGrec'd + inspect for tensile damage.  
ensure cap attached08/08/08

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC3	SECOND CHECK
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countersComment: SECOND CHECK inspect level 508/08/11 (X40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: CLAMP

Job Number: 40493

Part Number: D30411

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

RD 08/08/12

(40)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/13 (40)

8.0

POWDER COATING

POWDER COATING



M 108 523



(40)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask inside of 0.8120" diameter hole

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:20  
320°F  
10:50

M-1 08/08/13

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-08-13

(X40)

10.0

D2611

Bearing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bearing

Pick:

Qty Part Number Description Batch

1 D2611 Bearing

B39124x13/B40518x27

FF 08-08-14

(40)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Press D2611 bearing into lug as per Dwg D3041

2- Stake bearing into place as per Dwg D3041

FF 08-08-14

(40)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-08-15 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: CLAMP

Job Number: 40493

Part Number: D30411

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 465 (overstock)

AS 08/08/19 @C

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/20 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-19

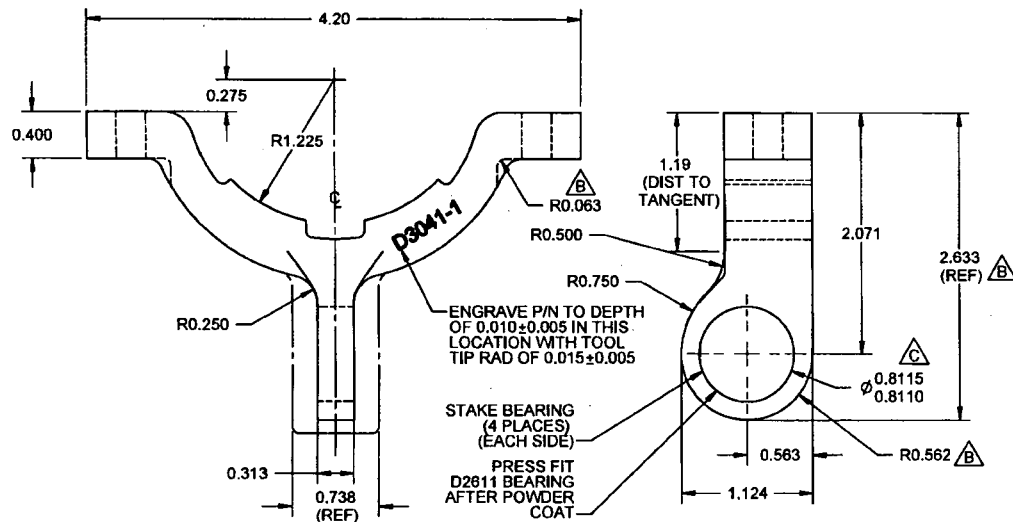
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

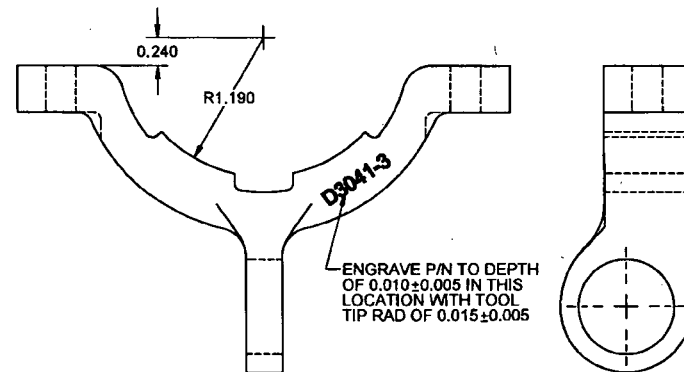
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



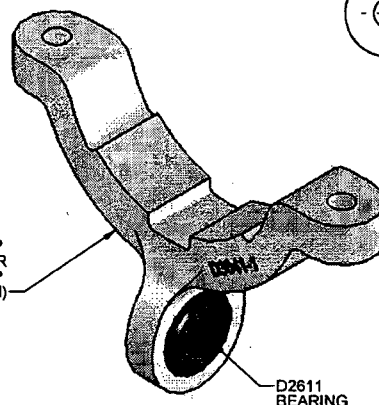
**D3041-1 CLAMP**



**RELEASED**

06.11.17

**D3041-3 CLAMP**  
(SAME AS D3041-1  
EXCEPT AS SHOWN)



- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
  - 6) STAKE D2611 BEARING AFTER POWDER COAT
  - 7) PART IS SYMMETRIC ABOUT C

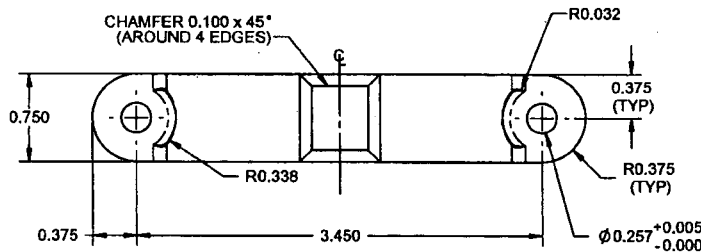
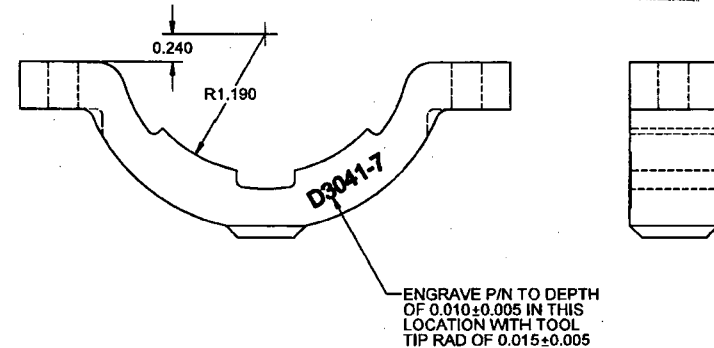
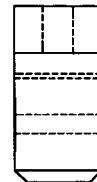
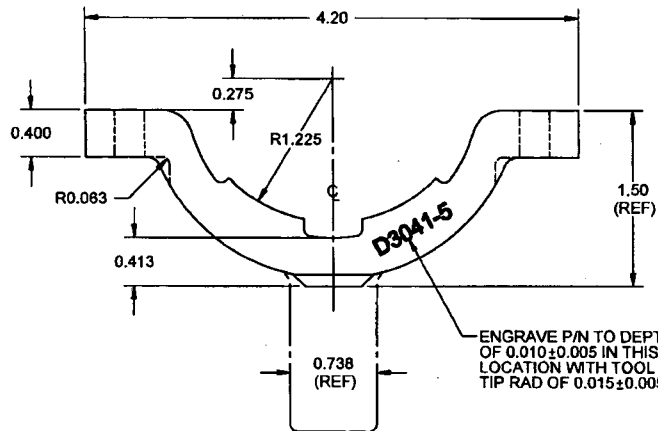
C	06.10.18	CHANGED BEARING HOLE TOLERANCE
B	06.06.05	CHG TO RND END DETAIL, 0.063 WAS 0.032, ADD TOL. & D3041-5A-7
A	01.06.28	NEW ISSUE
REV	DATE	DESCRIPTION
DESIGN	DRAWN BY	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. <b>D3041</b>
DATE	06.10.18	TITLE <b>CLAMP</b>
		REV. C SHEET 1 OF 2 SCALE 1:1

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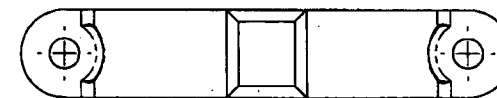
NO. 40493  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
ENGINEERING  
RETURN TO  
STOP COPY  
REPRODUCED COPY

RELEASED

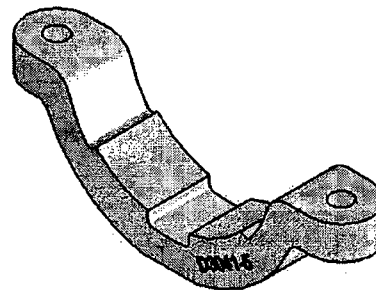
06.11.17



D3041-5 CLAMP



D3041-7 CLAMP  
(SAME AS D3041-5  
EXCEPT AS SHOWN)



- NOTES:
- 1) MATERIAL: MANUFACTURE FROM D2423 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK ALL SHARP CORNERS 0.010 TO 0.020
  - 6) PART IS SYMMETRIC ABOUT C

DESIGN 97	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED B	APPROVED H	DRAWING NO. D3041	REV. C SHEET 2 OF 2
DATE 06.10.18	TITLE CLAMP		SCALE 1:1
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SUBJECT TO AMENDMENT



## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

40  
40

D3041-1  
D3041-3

Lug B40493  
Lug B40494

6776  
6776

MATERIAL: supplied by DART D2423 B33310

*Solo*

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

*Shigi Walz*  
Shigi Walz

Vankleek Hill, August 8, 2008

